

Document made available under the Patent Cooperation Treaty (PCT)

International application number: PCT/CA05/000248

International filing date: 23 February 2005 (23.02.2005)

Document type: Certified copy of priority document

Document details: Country/Office: US
Number: 60/547,755
Filing date: 24 February 2004 (24.02.2004)

Date of receipt at the International Bureau: 27 April 2005 (27.04.2005)

Remark: Priority document submitted or transmitted to the International Bureau in compliance with Rule 17.1(a) or (b)



World Intellectual Property Organization (WIPO) - Geneva, Switzerland
Organisation Mondiale de la Propriété Intellectuelle (OMPI) - Genève, Suisse

PA 1290792



THE UNITED STATES OF AMERICA

TO ALL TO WHOM THESE PRESENTS SHALL COME:

UNITED STATES DEPARTMENT OF COMMERCE

United States Patent and Trademark Office

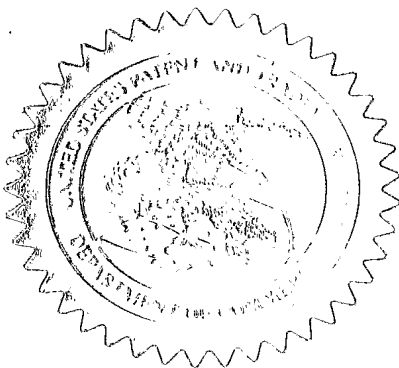
March 07, 2005

**THIS IS TO CERTIFY THAT ANNEXED HERETO IS A TRUE COPY FROM
THE RECORDS OF THE UNITED STATES PATENT AND TRADEMARK
OFFICE OF THOSE PAPERS OF THE BELOW IDENTIFIED PATENT
APPLICATION THAT MET THE REQUIREMENTS TO BE GRANTED A
FILING DATE UNDER 35 USC 111.**

APPLICATION NUMBER: 60/547,755

FILING DATE: February 24, 2004

**By Authority of the
COMMISSIONER OF PATENTS AND TRADEMARKS**



L. EDELEN
Certifying Officer

PROVISIONAL APPLICATION FOR PATENT COVER SHEET

This is a request for filing a PROVISIONAL APPLICATION FOR PATENT under 37 CFR 1.53(c).

Express Mail Label No. EV 325 708 266 US

INVENTOR(S)					
Given Name (first and middle [if any])		Family Name or Surname		Residence (City and either State or Foreign Country)	
Luc Jean-Francois		BELLEY BILODEAU		Jonquiere, Quebec, CANADA Jonquiere, Quebec, CANADA	
Additional inventors are being named on the _____ 1 _____ separately numbered sheets attached hereto					
TITLE OF THE INVENTION (500 characters max)					
METHOD OF PRIMING FILTER FOR MOLTEN METAL					
Direct all correspondence to: CORRESPONDENCE ADDRESS					
<input type="checkbox"/> Customer Number: _____					
OR					
<input checked="" type="checkbox"/> Firm or Individual Name		Christopher C. Dunham			
Address		COOPER & DUNHAM LLP			
Address		1185 Ave. of the Americas			
City		NEW YORK	State	NY	Zip 10036
Country		UNITED STATES	Telephone	212 278-0400	Fax 212 391 0525
ENCLOSED APPLICATION PARTS (check all that apply)					
<input checked="" type="checkbox"/> Specification Number of Pages		18	<input type="checkbox"/> CD(s), Number _____		
<input checked="" type="checkbox"/> Drawing(s) Number of Sheets		5	<input type="checkbox"/> Other (specify) _____		
<input type="checkbox"/> Application Data Sheet. See 37 CFR 1.76					
METHOD OF PAYMENT OF FILING FEES FOR THIS PROVISIONAL APPLICATION FOR PATENT					
<input type="checkbox"/> Applicant claims small entity status. See 37 CFR 1.27.				FILING FEE Amount (\$)	
<input checked="" type="checkbox"/> A check or money order is enclosed to cover the filing fees.				\$ 160.00	
<input checked="" type="checkbox"/> The Director is hereby authorized to charge filing fees or credit any overpayment to Deposit Account Number: 03-3125					
<input type="checkbox"/> Payment by credit card. Form PTO-2038 is attached.					
The invention was made by an agency of the United States Government or under a contract with an agency of the United States Government.					
<input checked="" type="checkbox"/> No.					
<input type="checkbox"/> Yes, the name of the U.S. Government agency and the Government contract number are: _____					

[Page 1 of 2]

Respectfully submitted,

Date February 24, 2004

SIGNATURE Christopher C. Dunham

REGISTRATION NO. 22,031

TYPED or PRINTED NAME Christopher C. Dunham

(if appropriate)

Docket Number: 72021 CCD

TELEPHONE (212) 278-0400

USE ONLY FOR FILING A PROVISIONAL APPLICATION FOR PATENT

This collection of information is required by 37 CFR 1.51. The information is required to obtain or retain a benefit by the public which is to file (and by the USPTO to process) an application. Confidentiality is governed by 35 U.S.C. 122 and 37 CFR 1.14. This collection is estimated to take 8 hours to complete, including gathering, preparing, and submitting the completed application form to the USPTO. Time will vary depending upon the individual case. Any comments on the amount of time you require to complete this form and/or suggestions for reducing this burden, should be sent to the Chief Information Officer, U.S. Patent and Trademark Office, U.S. Department of Commerce, P.O. Box 1450, Alexandria, VA 22313-1450. DO NOT SEND FEES OR COMPLETED FORMS TO THIS ADDRESS. SEND TO: Mail Stop Provisional Application, Commissioner for Patents, P.O. Box 1450, Alexandria, VA 22313-1450.

If you need assistance in completing the form, call 1-800-PTO-9199 and select option 2.

PROVISIONAL APPLICATION COVER SHEET
Additional Page

PTO/SB/16 (08-03)

Approved for use through 07/31/2006. OMB 0651-0032

U.S. Patent and Trademark Office; U.S. DEPARTMENT OF COMMERCE

Under the Paperwork Reduction Act of 1995, no persons are required to respond to a collection of information unless it displays a valid OMB control number.

Docket Number 72021 CCD

INVENTOR(S)/APPLICANT(S)		
Given Name (first and middle (if any))	Family or Surname	Residence (City and either State or Foreign Country)
Andre Serge	GENDRON MUNGER	Jonquiere, Quebec, CANADA Laterriere, CANADA

[Page 2 of 2]

Number 1 of 1

WARNING: Information on this form may become public. Credit card information should not be included on this form. Provide credit card information and authorization on PTO-2038.

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE


Applicants : Luc BELLEY et al.
Serial No.: not yet assigned
Filed : currently herewith
For : METHOD OF PRIMING FILTER FOR MOLTEN METAL

EXPRESS MAIL LETTER OF TRANSMITTAL

1185 Ave. of the Americas
New York, N.Y. 10036
February 24, 2004

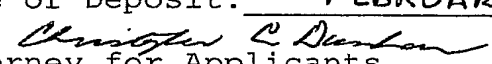
Commissioner for Patents,
P.O. Box 1450,
Alexandria, VA 22313-1450
S I R:

I hereby certify that the above-identified **provisional** patent application (consisting of **18** pages, **5** sheets of drawings, cover sheet, and fee check for **\$160**), is being deposited with the United States Postal Service "Express Mail Post Office to Addressee" service under 37 C.F.R. §1.10 on the date indicated below and is addressed to the Commissioner for Patents, P. O. Box 1450, Alexandria, VA 22313-1450.



Mailroom Employee *TRW* 1500A
Depositing Express Mail Material

Express Mail mailing label No. **EV 325 708 266 US**

Date of Deposit: FEBRUARY 24, 2004

Attorney for Applicants
Christopher C. Dunham,
Reg. No. 22,031
COOPER & DUNHAM LLP
Tel. (212) 278-0400

METHOD OF PRIMING FILTER FOR MOLTEN METAL

Field of the Invention

This invention relates to the filtration of molten metal, e.g. molten aluminum.

5 Background of the Invention

It is a common industrial practice to remove small inclusions from molten metals, such as molten aluminum, by filtration. A typical material used for such filters is a porous ceramic or refractory material through which the
10 molten metal is passed. These ceramic or refractory materials are not readily wetted by molten metals, and when such materials have relatively fine pore sizes, considerable difficulties are encountered in initiating the flow of metal through the filter (priming the filter) and
15 typically such materials require the use of deep filter boxes to create a metal head sufficient to overcome the priming difficulties that arise.

One solution to this problem has been proposed in Japanese Patent Publication JP 60-5829 that teaches the use
20 of a vacuum hood to prime a filter for filtering molten metal for use in producing ultra-pure metal. It had been found that with filters having small pore sizes, a substantial gauge pressure of metal is needed to prime the filter (in an example, gauge pressures of up to about an
25 atmosphere are indicated). According to this Japanese publication, a vacuum was produced by a vacuum pump connected to a buffer volume via a conduit to a vacuum hood. The vacuum pump was used to evacuate the buffer volume which was then applied to the filter on its downstream side.
30 A rapid vacuum release valve was provided to cut off the vacuum once priming had occurred.

In Japanese Patent Publication JP 06-49551 there is disclosed a continuous in-line filter device, based on a porous tube filter where a fan was used to force the metal that is passed through the filter element from the tube outlet. The fan operates only to blow and does not provide any suction.

A furnace stirring device is described in WO 88/07165 in which a molten metal in a closed side chamber was raised and lowered repeatedly to cause the metal to flow through shaped orifices and thereby cause mixing in the main furnace. The metal was raised and lowered by the alternate application of pressure and suction by a fan operating on the gas above the metal in the closed side chamber. There was no suggestion of the use of such a fan with a filter.

The present inventors were faced with the problem of trying to prime a relatively large commercial filter typically having a relatively large cross sectional area compared to its thickness. Such a filter has a relatively large exit well and it was found that a system such as that described in the JP 60-5829 document was not suitable. For instance, it was found that for the level of vacuum required in the JP 60-5829 system, a vacuum pump was needed and a typical vacuum pump is not able to remove air from a commercial exit well sufficiently fast. For a commercial operation with the larger filter, the need was not so much for a high level of vacuum but for being able to remove the air from the exit well at a sufficiently high rate.

Priming a commercial metal filter of substantial cross-section is a complex technical problem. If a vacuum is applied at a rate outside certain limits, the priming fails. If a rate of vacuum application is too large, the filter element can rupture. On the other hand, if the rate of application is too low, when the vacuum reaches a

certain critical level, the filter element may become primed only in a few locations, causing metal to start flowing through the filter only at those locations. When that happens, the vacuum that was developed is released so that the filter is no longer primed and there is no metal flow through the unprimed areas. The resulting filtration area is substantially reduced resulting in poorer filtration, increased metal level drop through the filter and in certain cases requiring that the process be halted.

Attempts were made to use a vacuum tank such as that shown in JP 60-5829, with the tank sized to contain sufficient gas volume at the final desired pressure which was by a separate vacuum pump prior to establishing a connection to the filter, and differed from the reference in that the vacuum pump was disconnected from the tank prior to connecting to the system. Apart from the need of a large vacuum tank, this approach also tended to create an uncontrollable evacuation rate, and if the system was not leak tight could result in insufficient final pressure to permit priming. It was not found to be a satisfactory arrangement for a large commercial filtering operation.

It is an object of the present invention to provide a priming system which could be adapted for use for large commercial filters for which the pore size is too small to permit priming in shallow filter boxes.

Summary of the Invention

In one aspect, the present invention relates to a method of priming an in-line molten metal filtration unit having a porous ceramic or refractory filter mounted substantially horizontally in a filter box. This filter box has an inlet for molten metal and an outlet for molten metal, the outlet being a closeable outlet in an exit well

connecting to the downstream side of the filter. The method of the invention comprises the steps of adding a molten metal to the filter box sufficient to entirely cover the upstream side of the filter with a depth of molten metal and temporarily closing the outlet in the exit well with a sealable cover. A steadily increasing vacuum is then applied to the closed exit well at a rate between 0.1 and 10 kPa per second by withdrawing a stream of air from the exit well by means of a fan until molten metal begins to flow through the filter. At that point the vacuum is quickly released and the sealable cover is removed from the molten metal outlet. Once the filter has been primed in this manner, flow of metal through the filter continues while requiring only a relatively low head of molten metal on the inlet side of the filter.

The use of a fan in the above manner has been found to have several important advantages. Firstly, a vacuum tank is not required and the fan is capable of removing air from the exit well very rapidly so that the level of vacuum required for priming of the filter is reached very quickly. Secondly, by a direct connection to a fan, it is possible to very quickly release the vacuum without any overrun when priming is achieved.

In an alternative embodiment of the invention it is possible to use an air venturi in place of the fan and achieve similar results.

The invention also relates to a novel apparatus for filtering molten metal. This apparatus includes a filter box, a feed trough for feeding molten metal into the filter box and a porous ceramic or refractory filter mounted substantially horizontally within the filter box to receive molten metal from the feed trough. An exit well is located beneath the filter for receiving filtered molten metal.

This exit well also extends laterally beyond the filter box and beneath a bottom portion of discharge trough. An opening in the discharge trough bottom portion connects to the exit well so that filtered molten metal can flow from the exit well into the discharge trough. A vertically movable closure unit is adapted to sit over and seal the opening between the discharge trough and the exit well. An air conduit is connected at a first end to the closure unit and at a second end to a fan or air venturi for withdrawing air from the exit well. The apparatus also includes means for raising and lowering the closure unit and a valve for releasing vacuum formed within the exit well.

Brief Description of the Drawings

In the drawings which illustrate the present invention:

Fig. 1 is a schematic illustration in partial section of the filtration unit of the invention;

Fig. 2 is a modification of the view of Fig. 1;

Fig. 3 is a perspective view of the filtration unit of the invention;

Fig. 4 is a further perspective view of the filtration unit of Fig. 3 from a different direction;

Fig. 5 is a micrograph showing how pore diameters are measured.

Fig. 6 is a plot showing increase in vacuum with time.

Description of the Preferred Embodiments

It is important for the control of the vacuum according to the present invention that the amount of vacuum increases steadily. In other words, from the start of priming to the point at which the vacuum is released, there is no decrease in vacuum. A steady increase may be

in the form of a series of step increases or as a straight line increase.

5 The fan used for priming is preferably connected to the exit well by means of a conduit having a valve venting to the atmosphere. Thus, when the vacuum is to be released, this valve is opened to the atmosphere.

10 The fan requirements will depend on the size of filter used but typically should be capable of evacuating to a vacuum of between 2 and 20 kPa, and to evacuate the filter outlet volume to the desired vacuum within about 1 to 120 seconds, preferably 2 to 30 seconds. A vacuum of 2 to 20 kPa means 2 to 20 kPa below the standard atmospheric pressure (101 kPa). Typically the type of fan that meets these requirements is a duct fan or regenerative blower.
15 However any fan meeting these requirements may be used. An air venturi sized to these requirements may also be used. A fan suitable for typical commercial filter installations and meeting the above requirements has an exhaust rate of 320 standard litres per minute at 6 kPa of vacuum.

20 It is also advantageous to connect the fan conduit to the exit well by way of a closure member which closes the exit well, including the molten metal outlet. Thus, when the closure member is in place, the exit well and outlet are sealed from the atmosphere. This closure member is
25 adapted so that when the vacuum is released, the closure member may be lifted from the top of the exit well and from the trough so that the exit well is immediately returned to atmospheric pressure and the trough is open to receive filtered molten metal.

30 In a preferred embodiment, the conduit may also include a three-way valve which permits the fan to draw air solely from the outside, or to apply vacuum solely to the filter, or any intermediate combination, by varying the

valve position between two extremes. In a typical operation the valve is placed in a position where the fan draws air solely from the exterior (and the filter is isolated), at which point the fan is started and run up to full speed. The valve is then moved gradually (e.g. by a motor control) toward the other extreme position so that the fan progressively draws a higher proportion of air flow from the filter box. This provides a smooth readily controlled ramp in the applied vacuum even when the seals between the closure member and the filter are variable or leaky.

A particular embodiment of a filtration unit according to the invention is shown Figures 1 and 2. The filtration unit includes a filtration box 10 having side walls and a bottom wall 14. These walls are formed of a heat resistant insulating material. At one side of the unit is a feed trough 16 for feeding molten metal 18 into the box. Within the box is a horizontal filter element 20 supported between side walls and an inner divider wall 22. An exit well 23 is provided beneath the filter 20 and a closeable outlet drain 32 is provided for emptying the filter box when necessary.

The exit well 23 includes an outlet opening 25 through which molten metal discharges to trough 28. For priming the filter 20, the opening 25 and exit well 23 are closed by means of a closure unit 24 which, as shown in Figure 1, sits over and seals the outlet opening 25. An opening in closure member 24 connects to a conduit 34 by way of a connector 30 and conduit 34 connects to a fan intake duct 36 containing a valve 38. This valve 38 can be moved between a position allowing flow through conduit 34 to the pump intake duct 36 or it can be switched to draw air in from the atmosphere by means of a motor drive. The valve

38 is such that at any position between these two extremes, the fan can draw a portion of air from the atmosphere and the remainder from the conduit 34. The connector 30 has a fast acting solenoid valve 31 connected to the atmosphere.

5 In the position shown in Figure 1, the filter unit is initially filled with molten metal 18 as shown and the fan 40 is started with the valve 38 fully open to the atmosphere and the conduit 34 shut off from the fan. The valve 38 is moved by a motor drive toward its other extreme
10 in order to gradually increase the proportion of air flow coming from the exit well 23 thereby creating a vacuum within the space beneath the filter. This vacuum quickly and smoothly increases by the action of fan 40 and valve 38 until the point is reached at which metal flow commences
15 through the filter 20 and priming has been achieved. At this point it is important to quickly release the vacuum and this is done by opening valve 31 to the atmosphere. To achieve a rapid release of vacuum the valve 31 is preferably a solenoid valve that is released upon detection
20 of molten metal in the bottom of the well 23, for example, by means of a conductive probe which detects the metal by completion of an electric circuit.

Once the vacuum is released, the closure 24 is lifted away from the filter box as shown in Figure 2 so that the
25 entire open end of exit well 23 is exposed to the atmosphere, and, of course, this also opens the discharge trough 28 to metal flow.

A more detailed version of the present invention is shown in perspective views in Figures 3 and 4. A
30 refractory lined filter box 10 typical of the size and type used for commercial ceramic foam filtration units is provided. A porous filter element 20 is mounted horizontally within the box. An inlet 16 and outlet 28

comprising refractory lined troughs are provided that are in turn connected to a conventional metal delivery system. Below the filter element, and not visible in Figures 3 and 4 in the exit well 23 connecting to outlet opening 25, as shown in Figures 1 and 2.

A removable cover 41 is provided for the filter box. The cover contains a burner 42 for preheating the filter element prior to use. The cover is mounted on a vertical post 43 and can be raised and swung out of the way when not required.

A closure 24 in the form of a hollow box with an open bottom is provided mounted on a post 44 so that it can be moved into position and lowered into the exit trough 28 so as to cover and seal the hole 25 and thereby seal off the exit well 23 under the filter element. The closure box 24 is connected by pipe 34 to a fan 40. Mounted on the connection pipe 34 and close to the closure is a quick opening solenoid valve 45 to release vacuum when the metal is detected in the exit well. The closure can be raised automatically (when metal is detected) by pneumatic means controlled by a controller 46 on the post. Metal is detected by electrical contacts 47 fed through the closure. These are in the form of steel or graphite tipped steel rods.

The priming is conducted within a time of about of 1 to 120 seconds, preferably in a time of about 2 to 30 seconds. This is with a filter having a filtration cross sectional area of about 4 to 1570 square inches (25.8 to 10130 square centimeters). The filtration area preferably is at least 100 square inches (645 square centimeters). This filter also typically has a thickness of about 0.5 to 4.0 inches (1.25 to 10.2 centimeters), preferably about 1 to 3 inches (2.5 to 7.6 centimeters).

The filter used can be selected from a variety of commercial filters and typically has a filter pore size ranging from an average of about 150 to 500 microns. This average pore size is defined as the average "window" or
5 size of interconnecting necks or passages between the cells of the porous refractory media.

The average pore size is measured as follows. A sample is cut from the filter media in the centre of the media thickness and perpendicular to the flow direction. From a
10 scanning electron micrograph of the sample, the size of the "windows" visible between the ceramic necks is measured and the average value over the sample is determined. Figure 5 shows a typical result for such measurements. Pores that have a diameter below 50% of the average of all pores
15 measured are not taken into account in the final average pore size calculation because they will not be primed by molten metal.

Filters having an average pore size greater than 500 microns typically can be started without the need of
20 priming, while filters having an average pore size below 150 microns may be capable of being primed by applying a vacuum to the exit well, but will require an excessive head of metal above the filter to continue the filtration without the vacuum.

25 Filters of this type are conventionally defined in terms of pore per inch (ppi), but this parameter is not a unique definition of average pore size since it depends on the manufacturing methods used. For comparison, certain commercial filter media are listed in Table 1 below:

Table 1

Media designation	Average pore size ("Window")
Selee 30 PPI PBA	840 microns
Vesuvius 30 PPI Sintered Alumina	690 microns
Sivex 30 PPI PBA	930 microns
Vesuvius 50 PPI Sintered Alumina	590 microns
Selee 70 PPI PBA	380 microns
Vesuvius 80 PPI Sintered Alumina	240 microns
Sivex 80 PPI PBA	390 microns

The first four items in the above table are filter materials that are typically used in low depth CFF boxes for filtering metal in commercial casting plants. The last three materials are not used in conventional systems unless very high metal heads can be provided for priming. They are typical of the filter media that may be conveniently used with the present invention.

The depth of metal over the filter is defined as the sum of the vertical distance from the trough bottom to filter top (VDTF) plus the height of the metal in the trough. The height of metal in the trough would generally range from about 8 to 12 inches (20 to 30 cm). With the procedure of the present invention, the VDTF typically ranges from about 0 to 4 inches (0 to 10 cm) and, therefore, the depth of metal over the filter will typically be about 8 to 16 inches (20 to 40 cm). In a typical filter, the VDTF ranges from 0 to 20 inches (0 to 50 cm) and therefore the depth of metal over the filter will be from 8 to 32 inches (20 to 80 cm).

Thus it can be seen that the filter box size (i.e. the filter cross section and depth required to accommodate the

metal head over the filter) can be less in the present invention than in conventional ceramic filtration equipment or can be installed in substantially the same space as an existing conventional ceramic filter. Furthermore, since a low average pore size medium is used in the present invention, the filtration efficiency is higher than in conventional ceramic filters and is closer to the efficiency of deep bed filters which occupy substantially larger volumes. The smaller volume of the present invention compared to both conventional ceramic filter units and bed filters means that less metal must be drained at filter change.

The invention has been shown with a single filter element mounted in the filter box. However, it will be understood that other configurations known in the art may be used with the invention. For example, the single filter element may be replaced by two or more, mounted beside each other to permit larger cross-sectional areas than may be possible with a single element. In addition, use of two filter elements mounted one above the other in the filter box (for example as illustrated in US patent 5,673,902 assigned to Selee Corporation) is possible with this invention.

Example 1

A test was conducted on a pilot filtration unit of a design as shown in Fig. 1. The filter used was a commercially available filter having a pore density of 70 pores per inch (PPI). It had a thickness of 2 inches (5.1 cm) and a cross-sectional area of 144 square inches (929 square centimeters). The exit well was connected by way of a conduit to the intake of a duct fan (Spencer VB-055 manufactured by The Spencer Turbine Company, Windsor, CT

USA), the conduit including a venting valve and a three-way valve for bleeding atmospheric air into the air being drawn into the fan.

5 Molten aluminum alloy was added to the filtration unit to a depth of about 8 inches (20 cm) above the filter. With the exit well and molten metal outlet trough closed, the fan was started and a three-way valve progressively moved by a motor to draw an increasing proportion of air from the exit well and a decreasing proportion of air from
10 the atmosphere. The filter is primed within about 10 seconds, at which point the vacuum had reached a level of about 6 kPa. At this point the venting valve in the conduit was opened and the exit well and molten metal outlet were also immediately opened. The results are
15 shown in the graph in Figure 6 where line 42 shows a steadily decreasing pressure and the point 44 indicates the point at which metal is detected in the bottom of the exit well 26 showing that priming has been achieved.

WE CLAIM AS OUR INVENTION:

1. A method of priming an in-line molten metal filtration unit having a porous ceramic or refractory filter mounted substantially horizontally in a filter box having an inlet for molten metal and an outlet for molten metal, the outlet being a closeable outlet in an exit well connecting to the downstream side of the filter,

the method comprising the steps of adding sufficient molten metal to the filter box to fully cover the upstream side of the filter with a depth of molten metal, temporarily closing the molten metal outlet in the exit well with a sealable cover, applying a steadily increasing vacuum to the closed chamber at a rate between 0.1 and 10 kPa per second by withdrawing a stream of air from the exit well through a fan or air venturi until the molten metal begins to flow through the filter and then immediately releasing the vacuum and removing the sealable cover from the molten metal outlet.

2. A method as claimed in claim 1 wherein the stream of air is withdrawn from the exit well by means of a fan.

3. A method as claimed in claim 1 wherein the stream of air is withdrawn from the exit well by means of an air venturi.

4. A method as claimed in claim 2 wherein the fan is connected to the exit well of the filter box by way of a conduit having a valve for venting to the atmosphere and the vacuum is released by opening this valve to the atmosphere.

5. A method as claimed in claim 4 wherein the conduit is connected to the sealable cover and when the vacuum is to be released the sealable cover is removed from the exit well and molten metal outlet.
- 5 6. A method as claimed in claim 3 wherein the conduit also includes a three way valve for bleeding atmospheric air into the air stream being drawn into the fan.
7. A method as claimed in claim 6 wherein the priming is conducted within a time of about 1 to 120 seconds.
- 10 8. A method as claimed in claim 7 wherein the time is about 2 to 30 seconds.
9. A method as claimed in claim 7 wherein the filter has a filtration area of about 4 to 1570 square inches (25 to 10130 square centimeters).
- 15 10. A method as claimed in claim 7 wherein the filtration area is at least 100 square inches (645 square centimeters).
11. A method as claimed in claim 7 wherein the filter has a thickness of about 0.5 to 4.0 inches (1.25 to 10.2 centimeters).
- 20 12. A method as claimed in claim 11 wherein the thickness of the filter is about 1 to 3 inches (2.5 to 7.6 centimeters).
13. A method as claimed in claim 11 wherein the filter has an average pore size of about 150 to 500 microns.
- 25 14. An apparatus for filtering molten metal comprising a filter box, a feed trough for feeding molten metal into the filter box, a porous ceramic or refractory filter mounted

substantially horizontally within the filter box to receive molten metal from the feed trough, an exit well beneath the filter for receiving filtered molten metal, said exit well extending laterally beyond the filter box and beneath a
5 bottom portion of a discharge trough, said trough bottom portion having an opening connecting the discharge trough to the exit well, a vertically movable closure unit adapted to sit over and seal the opening between the discharge trough and exit well, an air conduit connected at a first
10 end to the closure unit and at a second end to a fan or air venturi for withdrawing air from the exit well, a valve for releasing vacuum formed in the exit well and means for raising and lowering the closure unit.

15 15. An apparatus as claimed in claim 14 wherein the air conduit second end is connected to the intake of a fan.

16. An apparatus as claimed in claim 15 wherein the air conduit second end includes a three-way valve for bleeding atmospheric air into the air in the conduit being withdrawn from the exit well.

20 17. An apparatus as claimed in claim 15 wherein the fan is adapted to apply a steadily increasing vacuum to the closed chamber at a rate between 0.1 and 10 kPa per second.

25 18. An apparatus as claimed in claim 15 wherein the vacuum-releasing valve is connected to the vertically movable closure unit.

19. An apparatus as claimed in claim 18 wherein the vertically movable closure unit includes electrical contacts extending from the bottom thereof for detecting the presence of molten metal.

20. An apparatus as claimed in claim 14 wherein the filter box includes a removable cover.

21. An apparatus as claimed in claim 14 wherein the filter has a filtration area of about 4 to 1570 square inches (25
5 to 10130 square centimeters).

22. An apparatus as claimed in claim 14 wherein the filtration area is at least 100 square inches (645 square centimeters).

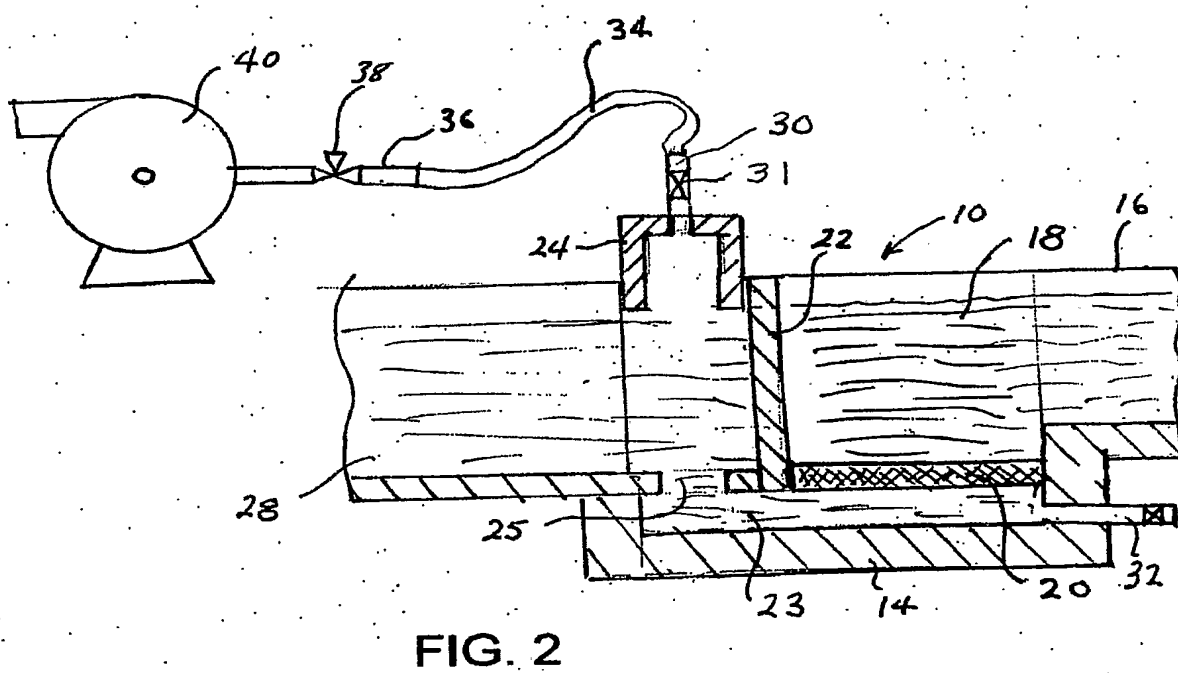
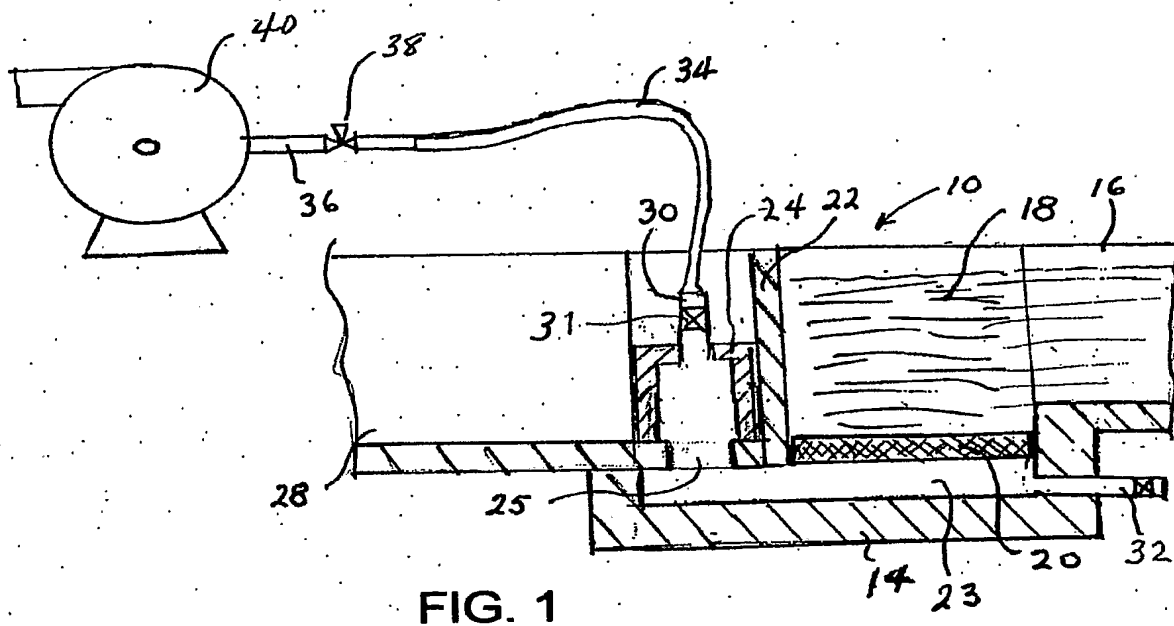
23. An apparatus as claimed in claim 14 wherein the filter
10 has a thickness of about 0.5 to 4.0 inches (1.25 to 10.2 centimeters).

24. An apparatus as claimed in claim 14 wherein the thickness of the filter is about 1 to 3 inches (2.5 to 7.6 centimeters).

15 25. An apparatus as claimed in claim 14 wherein the filter has an average pore size of about 150 to 500 microns.

Abstract

A method is described for priming an in-line molten metal filtration unit having a porous ceramic or refractory filter mounted substantially horizontally in a filter box. This filter box has an inlet for molten metal and an outlet for molten metal, the outlet being a closeable outlet in an exit well connecting to the downstream side of the filter. The method of the invention comprises the steps of adding a molten metal to the filter box sufficient to entirely cover the upstream side of the filter with a depth of molten metal and temporarily sealing the outlet in the exit well. A steadily increasing vacuum is then applied to the closed exit well at a rate between 0.1 and 10 kPa per second by withdrawing a stream of air from the exit well by means of a fan or air venturi until molten metal begins to flow through the filter. At that point the vacuum is quickly released and the molten metal outlet is opened. Once the filter has been primed in this manner, flow of metal through the filter continues while requiring only a relatively low head of molten metal on the inlet side of the filter.



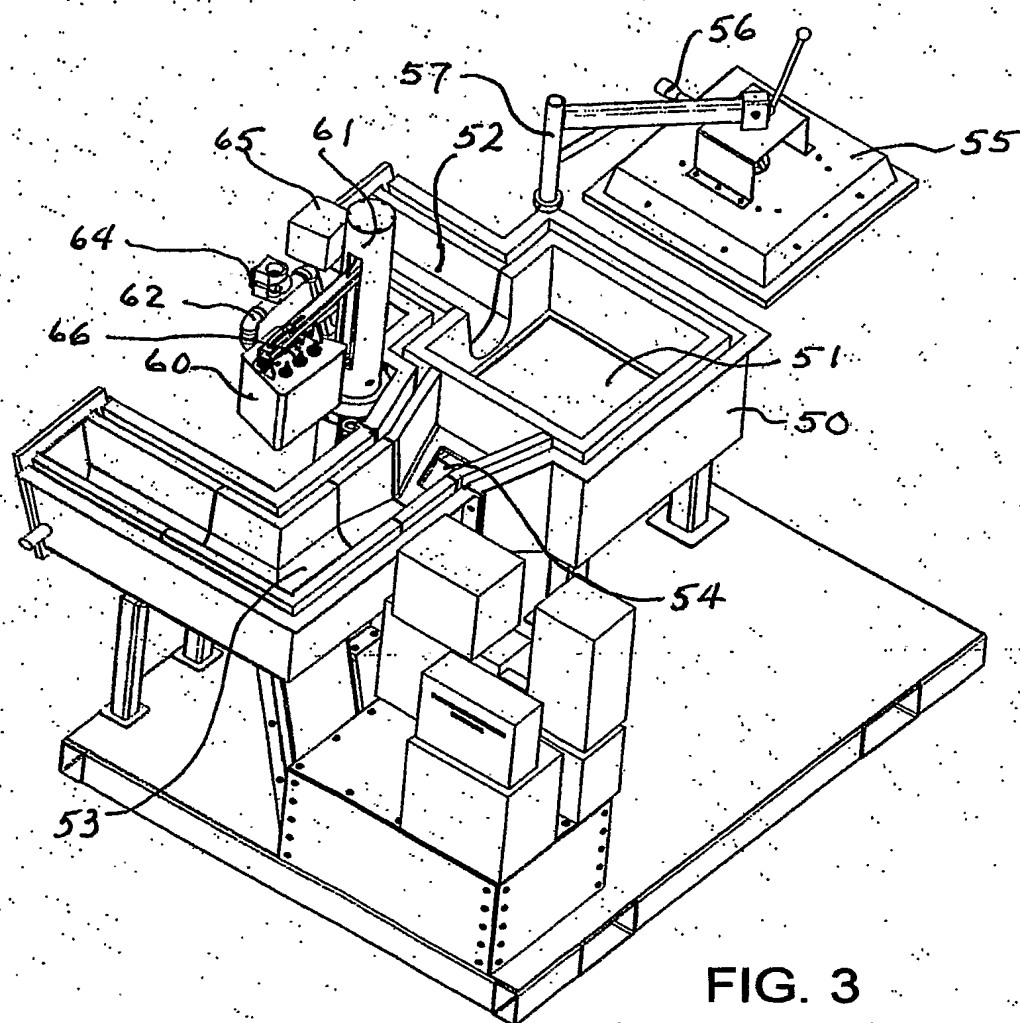


FIG. 3

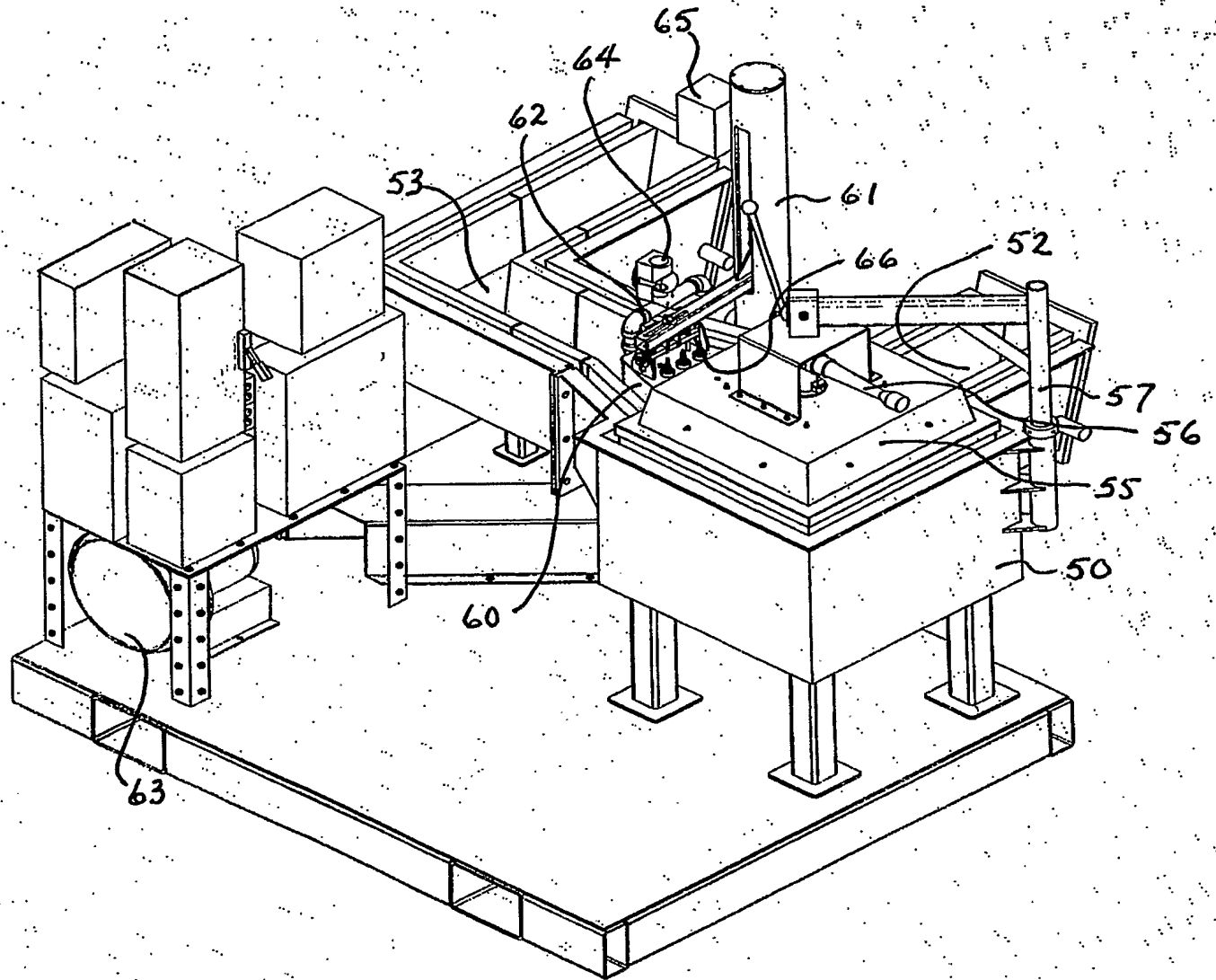




Fig. 5

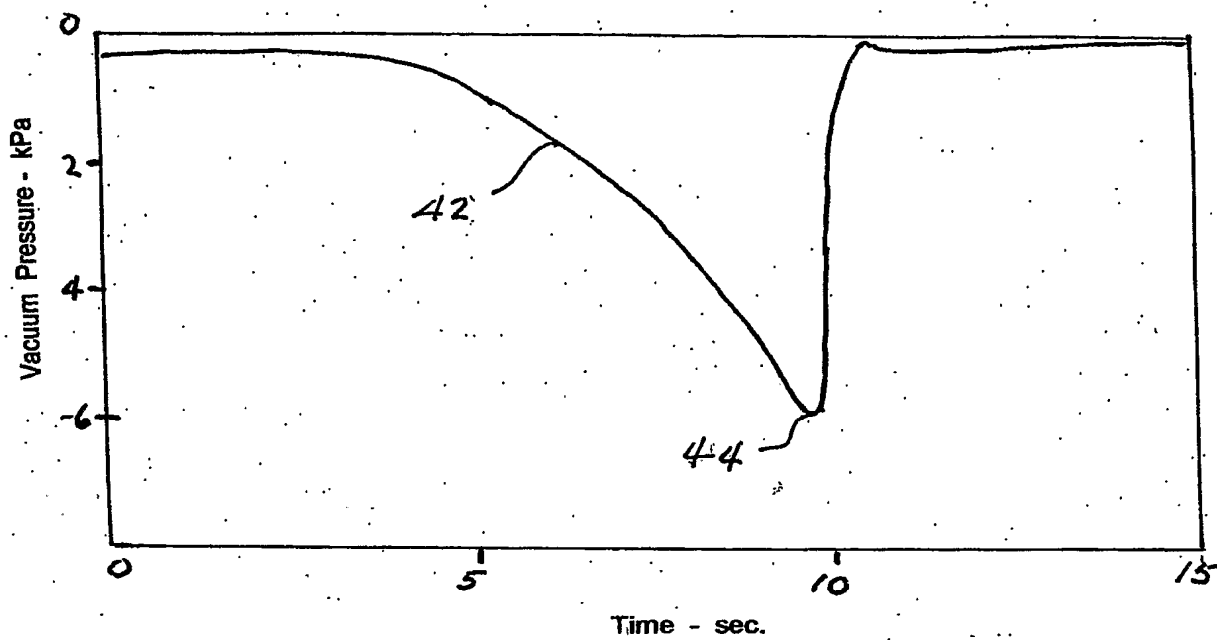


FIG. 6